



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.0210
Job Sheet 185797



Part No: 647.0210

Job Qty: 15 ea

Part Name: Rail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-1		DJP 18-11-14
100	Bandsaw	15 pcs	11/23/18	11/23/18	0.00	0.12	Bandsaw1		DJP 18-11-14
110	CNC Vertical Machining	15 pcs	11/23/18	11/23/18	0.67	15.15	HAAS1-1		DJP 18-11-14
120	QC	15 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-1		DJP 18-11-14
130	QC	15 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-1		mm 18/11/14
140	Outsource	15 pcs	11/23/18	11/23/18			ATG001-VC	15	NOV 27 2018
150	Packaging	15 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		NOV 27 2018
155	QC	15 pcs	11/23/18	11/23/18	0.00	0.00	QC5		NOV 27 2018
180	Packaging	15 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		NOV 27 2018
190	QC21-SA	15 Ea	11/23/18	11/23/18	0.00	0.00	QC21		NOV 27 2018

Part Op 100 - Cut Blank at 15.800"

Descriptions: 110 - 1-Machine per folio FB138

140 - Issue P/O to ATG : 80041742 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	19.8000 ft (1.32 ea)	90-Start up Operation	5103105

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.750X2.250	20	112	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rail	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	0.201
2	Rail	0.229Inches ± 0.005	0.234 0.224		0.230
3	Rail	0.190Inches ± 0.010	0.200 0.180		0.195
4	Rail	1.100Inches ± 0.010	1.110		1.095

QA DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

			1.090	
5	Rail	0.830Inches $\pm$ 0.005	0.835 0.825	0.830
6	Rail	2.000Inches $\pm$ 0.010	2.010 1.990	1.999
7	Rail	0.340Inches $\pm$ 0.000 - 0.005	0.340 0.335	0.339
8	Rail	0.125Inches $\pm$ 0.005	0.130 0.120	Radius 0.125
9	Rail	0.063Inches $\pm$ 0.005	0.068 0.058	Radius 0.063

Plex 11/2/18 10:06 AM Dart.lajeunesse.marie

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9-89

18/11/12



Container No: S127577



Part: 647.0210

Job No: 185797

Serial No/Batch: S127577

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
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PURCHASE ORDER **PO041742**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041742

PO Date: 11/15/18

Due Date: 11/21/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185601	D5582-1	Aft Angle : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL- A-8625, Type II, Class 2 as per Dwg. D5582 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	11/28/18	10 pcs	0 pcs	10 pcs	\$8.45/pcs	\$84.50
2	178976	RBE703A94- 1130-01-05	Fixture Handle -Issue P/O to ATG: AS PER DWG RBE703A94- 1130-01-05 - ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1 - Certification of Conformity is required	Firmed	-	11/21/18	41 pcs	0 pcs	41 pcs	\$3.80/pcs	\$155.80

41 X NOV 20 2018

Line Item Note ** can we have this end of day on the 20 or the morning of the 21? ** :



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PURCHASE ORDER **PO041742**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	178971	RBE703A94-1130-01-29	Tab Adjuster Clamp : URF 17-623 -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 - Certificate of Conformity is required	Firmed	-	11/21/18	20 pcs	0 pcs	20 pcs	\$3.80/pcs	\$76.00
20 X NOV 20 2018											
Line Item Note ** can we have this end of day on the 20 or the morning of the 21? ** :)											
4	185797	647.0210	Rail Issue P/O to ATG : AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N	Firmed	-	11/28/18	15 pcs	0 pcs	15 pcs	\$12.25/pcs	\$183.75
15 X NOV 27 2018 DAS 68 9-89											
Grand Total:											\$500.05

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Dart Aerospace Ltd.
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PURCHASE ORDER PO041742

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/16/18 10:20 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916614

Date: 26-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
15 ea	Part: 647.0210 ✓ Rev: N/C Rail Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 24154 PO: PO041742 ✓ Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>26/11/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

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